Work	Order	ID	61702
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Tuesday, August 31, 2010 1:19:39 PM



Page 1

Item ID:

D3791-1

Accept



Setup Start

Stop

Start



Revision ID:

Item Name:

Start Date:

Wearplate

8/31/2010

Start Qty: 12.00 Req'd Qty: 12.00 **Cust Item ID: Customer:**

Reference:

Approvals:

Sequence ID/

Process Plan:

Date 15-8-31

Tooling:

Date:

Stop

Qty

Run

Required Date: 9/7/2010

QC:

Date:

SPC (Y/N):

Date:

Tool ID

Accept

Reject

Insp.

Work Center ID

Operation Description

Revision Nbr

Set Up/ **Run Hours**

Tool # Plan Code

Qty

Reject Number

Stamp

Draw Nbr

D3791 Rev A

100

Waterjet

FLOW CNC Waterjet

304.063

FLOW WATER JET

Memo

1-Cut as per Dwg D3791 Dwg Rev:

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

Prog Rev:

2-Deburr if necessary

B10-9-

110

QC

Memo

0.00

0.00

Quality Control

W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	DCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:								
·	R	esolution:							Date: _	
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DATE	STEP	Description of NC			ction B	0: 0	Verific	cation	Approval	Approval
DAIL	JIL.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
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Tuesday, August 31, 2010 1:19:39 PM



Page 2

Item ID:

D3791-1



Setup Start



Revision ID:

Item Name: Wearplate

Start Date: 8/31/2010 Required Date: 9/7/2010

Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Stop



Date:_____

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan

Date:

Accept Qty

Reject

Reject Insp.

Sequence ID/ Work Center ID

120



Quality Control

Operation **Description**

NC BRAKE

QC8- Inspect parts - second check

Memo

Code

Qty

Number Stamp

130

Brake NC Brake NC

Memo

Memo

1-Deburr if necessary

2-Form on Brake as per Dwg D3791 using Jigs

0.00

0.00

\$ 10109109

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Ensure Joggle as per dwg D3429

Duit Ac	OSPACE	LIG							1
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Disposit	ion:	_ QA: N/C CI	osed:		Date: _	
NCR:			WORK OR	DER NON-CONFORMA	NCE (NCF	R)			
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Tuesday, August 31, 2010 1:19:39 PM



Page 3

Item ID:

Revision ID:

D3791-1

Item Name:

Wearplate

Start Date: 8/31/2010 Required Date: 9/7/2010

Start Qty: 12.00

Req'd Qty: 12.00



Setup Start

Stop



Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

SPC (Y/N):

Accept

Date: Date:

Run

Start

Stop



Sequence ID/ **Work Center ID**

150

Large Fab

Large Fab

Operation Description

Large Fab

1-Weld hardcoat as per dwg D3791 OSI004 Hardcoat 2059b Batch: M115553

Date: _____

0.00

Set Up/ **Run Hours**

0.00

Tool ID

Cust Item ID:

Customer:

Tool # Plan Code

Accept Qty

Reject **Qty**

Reject Number Stamp

Insp.

OZ 10-9-2

160

OC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

2 world

Memo

Memo

170

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

Sistorla

Dail Aci	OSPace	Liu							1
W/O:			WO	RK ORDER CHANGES					!
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC	<u> </u>	Corrective Action Section E		Verifica	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sectio	n C	Chief Eng	QC Inspector
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Page 4

Item ID:

D3791-1

Revision ID:

Item Name: Wearplate

Start Date:

Required Date: 9/7/2010

8/31/2010

Start Qty: 12.00



Date:

Accept



Setup Start





Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date:_____ Tooling:

SPC (Y/N):

Date: Date:

Run Start

Stop



Sequence ID/ Work Center ID

180

Powdercoat

Powder Coating

Operation Description

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

START TIME:

Set Up/

Run Hours bx 10-9-22

Tool ID

Cust Item ID:

Customer:

Tool # Plan Code Qty

Reject Accept **Qty**

Reject Insp. Number

Stamp

0.00

FINISH TIME: 12

QC3- Inspect Part Finish

Memo

=) M 10/09/27

190

OC

Quality Control

0.00

200

Packaging

Memo

0.00

Identify as per dwg & Stock Location: PP-17 0.00 BR 10-9-22

Packaging

	•								
W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	_ Date: _	
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NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
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Page 5

Item ID:

D3791-1



Setup Start

Stop



Revision ID:

Item Name: Wearplate

Required Date: 9/7/2010

Start Date:

8/31/2010 **Start Qty: 12.00**

Cust Item ID: Customer:

Reference:

A	nn	ro	امر	le.
A	DD	ro	vai	ıs:

Process Plan:

Date:_____

Tooling:

Accept

Date:

Tool ID

Run Start

QC:

Date:_____

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

210

Operation Description

Req'd Qty: 12.00

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

Tool # Plan

Code

Accept Qty

Reject Reject Qty Number

Insp. Stamp

Memo

0.00

0.00

Quality Control

MF 10-9-22

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W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		Description of NC		Corrective Action Secti	Section B Verifica			cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & late			Chief Eng	QC Inspector
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Picklist Print

Tuesday, August 31, 2010 1:19:43 PM

Work Order ID: 61702

Parent Item: D3791-1

Parent Item Name: Wearplate



Start Date: 8/31/2010

Required Date: 9/7/2010

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

IPP Rev:B

08-05-13 new issue DD verified by:EC 08-05-22 revA as per dwg ECN1191 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA	14(1) 410 () 1 6 7 1 17 1	Purchased	No		100	sf	82.9000	0.2917	3.684632	,		
304/316 Sheet .063									(B)	0-9-7		

Location Loc Qty Loc Code MAT20 82.9 115440 82.9

115440



W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	C	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Ye	s No	DQA	:	Date:	
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DATE	STEP	Description of NC			tion B		Verifica		Approval	Approval
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DART AEROSPACE LTD	Work Order:	61702
Description: Wearplate	Part Number:	D3791-1
Inspection Dwg: D3791 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

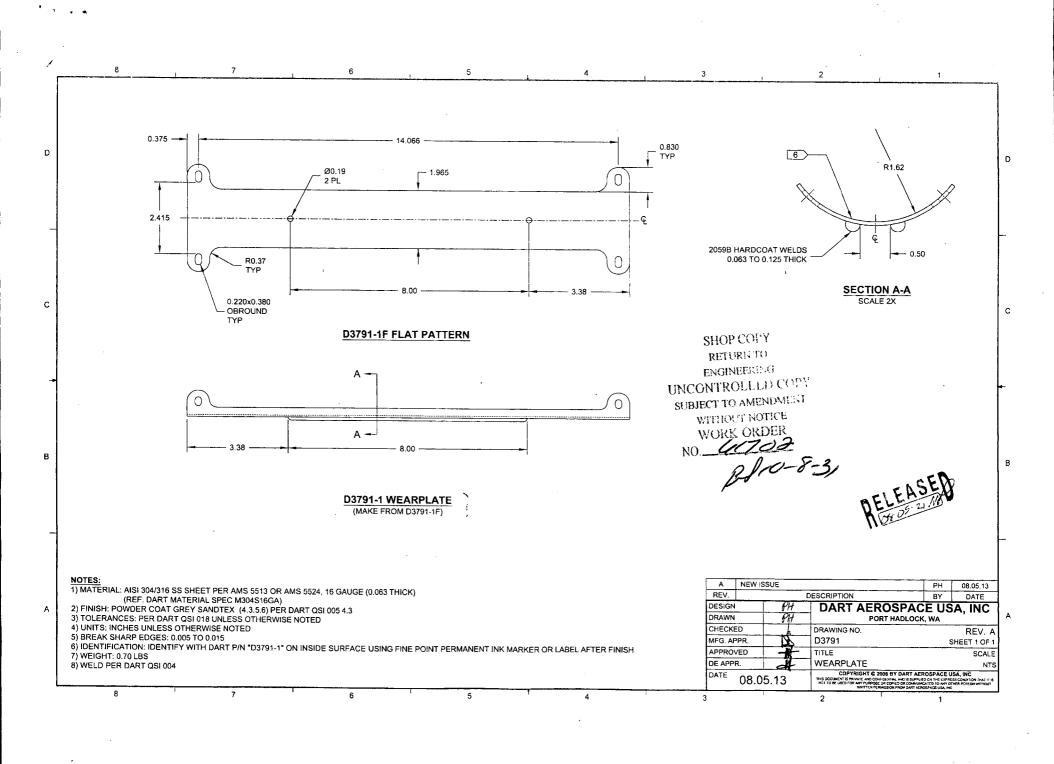
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.189	>		V 1802	
0.220 x 0.380	+/-0.010	085,×166,	×		V	
1.965	+/-0.010		A		V	
2.415	+/-0.010	7.415	*		V	
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3.38	+/-0.030	3.379	×		V	
0.830	+/-0.010	268,	*		V	
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Measured by:	Audited by: 8	Prototype Approval:	N/A
Date: 10-9-7	Date: 10/09/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.05.30	New Issue	KJ/DD	N
				Andrew Control

ospace I	Lta							
		W	ORK ORDER CHANG	GES				
STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Resolution:			Disposition:			_ QA: N/C Closed:		
	· V	ORK ORD	ER NON-CONFORM	IANCE (NC	R)			
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Dart Aerospac	e Ltd
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